

Date: Monday, 12/03/2007 12:39:16 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 WEARPLATE
Job Number : 31166	
Estimate Number : 12651	
P.O. Number : N/A	Part Number : D35651
This Issue : 12/03/2007 S.O. No. : N/A	Drawing Number : D3565 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : U/R
Previous Run : 30312	Material : N/A
Written By : _____	Due Date : 16/03/2007
Checked & Approved By : _____	Qty: 1 Um: Each
Comment : Est Rev : A New Issue 07-01-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.3759 sf(s)/Unit Total : 0.3759 sf(s)

304/316 .040 Sheet

Batch: M101463

7518

ml 07 03 14

(2)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: Prel

Prog Rev: Prel

ml 07 03 14

(2) ✓

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 14

(2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07 03 14

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

form 90 deg bend as per Dwg D3565

✓

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 31166

Part Number: D35651

Job Number:



Eng Approval  
CB 07.03.21

Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form "Cups" using DT8902 FORMING TOOL.

2-Oen Holes to .257" as per Dwg D3565, after forming.

SB 07/03/14 ✓

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld hard facing as per Dwg D3565 using DT8903 Holding Plate

A/R 2059B Hard Coat rod Batch: M02755

FC 07/03/22

10.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

11.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/3/26 (2)

SD

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Drawing Name: R44 WEARPLATE

Job Number: 31166

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/03/07*  
*RG7/03/07*

Job Completion



*U J7.B.16/*

Job/Project Number: 00062

Design Engineer/Project Manager Signature: CB

Date: 07.03.12

Design Manager Signature: [Signature]

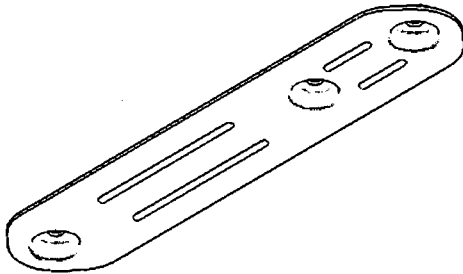
Date: 07.03.12

### PROTOTYPE REQUEST FORM

Item	Part Number	Drawing Number Date	Qty	Material Cert Required (Y/N)	Due Date	Complete Date	Comments
1	D3565-1	07.03.12	1	N	07.03.16	07.03.16	- no not weld or powder coat - only machining and forming

# PRELIMINARY ISSUE

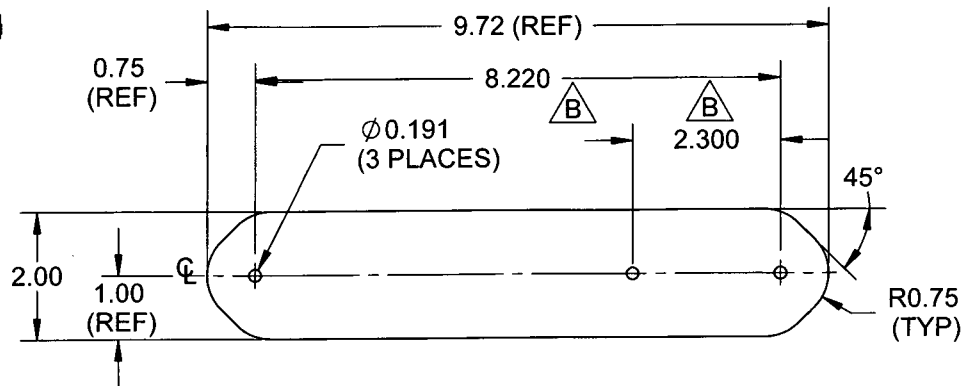
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3565	REV. B SHEET 1 OF 1
DATE 07.03.12	TITLE R44 WEARPLATE		SCALE 1:3
REV	DATE	DESCRIPTION	
A	07.01.09	NEW ISSUE	
B	07.03.12	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	



**UNDER REVIEW**

07.03.12 CB

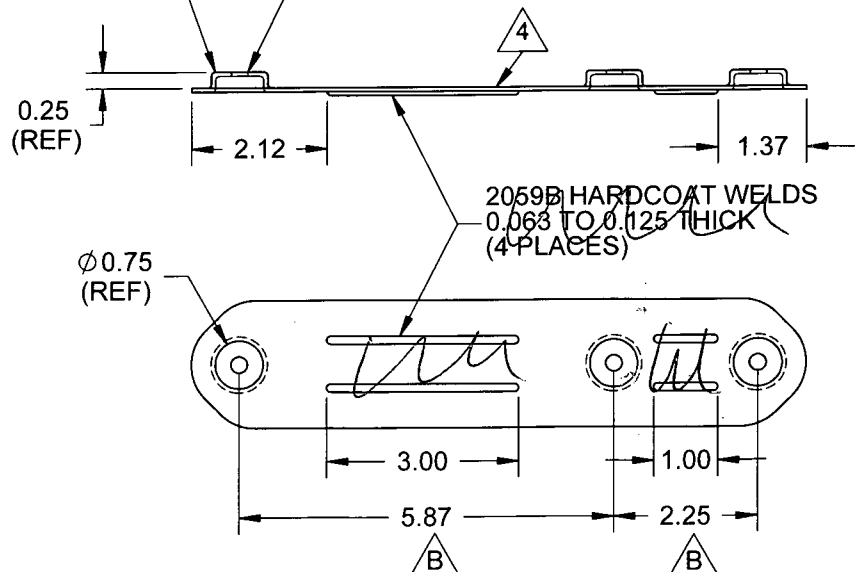
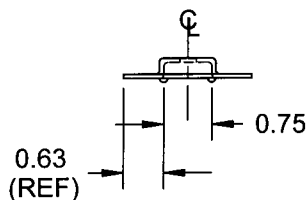
prototype



**D3565-1F FLAT PATTERN**

PUNCH  $\phi 0.191$  HOLES WITH  
 $\phi 0.75 \times 0.25$  DEEP PUNCH TOOL  
(3 PLACES)

OPEN HOLES TO  $\phi 0.257$  AFTER  
PUNCHING OPERATION (IF NECESSARY)



Do not weld  
or powder  
coat

**D3565-1 R44 WEARPLATE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT C

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